

6061-T6 RB.750

Work Order ID 147380***147380***

Page 1

Item ID: D3137-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Washer

Start Date: 6/7/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/10/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

MJS

Date:

JUN 10 2016

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3137	Rev F								
100	Hardinge CNC LATHE SMALL	0.00				22	Ø		DAS 49 9-89 16/06/16
100									
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	1-Machine as per Folio FA471 and Dwg D3137 2-Identify as D3137-5 3-Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				22	Ø		DAS 49 9-89 16/06/16
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				22	Ø		DAS 08 9-89
120									
QC	Memo	0.00							
Quality Control									

B.O 16/06/20

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								

DQA: _____ Date: _____



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																								OTHER : _____																																							

Work Order ID 147380

147380

Page 3

Wednesday, June 08, 2016 3:08:31 PM

Item ID: D3137-5 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Washer
Start Date: 6/7/2016 Start Qty: 10.00 *10* Cust Item ID:
Required Date: 6/10/2016 Req'd Qty: 10.00 *10* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-29		
170									
QC	Memo	0.00							
Quality Control									

JUN 24 2016

MCS JUN 24 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Order update only ☐

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Picklist Print

Wednesday, June 08, 2016 3:08:34 PM

Page 1

Work Order ID: 147380

147380

Parent Item: D3137-5

D3137-5

Parent Item Name: Washer

Start Date: 6/7/2016

Required Date: 6/10/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A04.11.04New issueKJ/JLM
IPP Rev B 08.07.03 ECN1207 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased		No		100	f	25.7465	0.0208	0.218947			

M6061T6R0 750

6061-T6 Round Bar .750"

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT012	25.7465	
m131999	1.2705	
m133560	2.069	
m134158	8.957	
m134551	13.45	

DAS
49
9-89

16/06/16

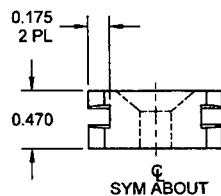
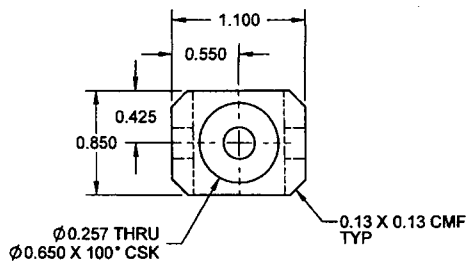
DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

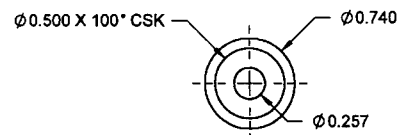
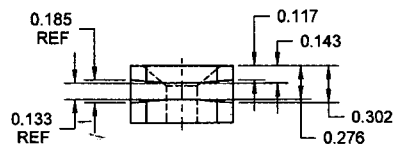
QA Closed: _____ Date: _____

Work Order update only ☐

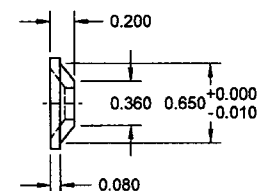
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Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____																						
Misidentified ☐	☐	Past Due ☐																							



D3137-3 GUIDE



D3137-5 WASHER



NOTES:

- 1) MATERIAL: -3
DELTRIN II 150E OR ACETRON GP ACETAL, BAR
(REF DART SPEC M-DELTRIN-B)
-5
6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR
PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4116)
OR PER-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207
-5 REPLACES PREMIER P/N B30-2300-209

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
DATE	08.05.30	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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DART AEROSPACE LTD
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